

Work Order ID 82532

April-02-12 3:09:35 PM

82532

Ship May 14

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 02/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 04/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MLJ* Date: *12/04/02* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3915	C

100 Weld per dwg A/R Aluminum rod Batch: *119785* 0.00
 Large Fab *120854*

100
Large Fab

Large Fab

Memo 0.00

1- assemble ribs, weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****

2- weld hinge, label plate and Mounting plates as per dwg D3915

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
QC

Quality Control

Memo 0.00

1 - 12.04.26

12.04.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5.7/6/27		(u)			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***	0.00 0.00				1	0	12-4-27	
140 *140* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 120854 Memo 1- weld (4) corners	0.00 0.00				1	0	12.04.30	

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

1 0 BE12/05/02

155

QC6- Inspect dimensions to drawing

0.00

155

QC

Memo

0.00

Quality Control

5/7/12

TC

inspect fit of lid with base

157

Chemical Conversion Coat per QSI005 4.1

0.00

157

HandFinish

Memo

0.00

Hand Finishing

1- realodine corners
do not acid etch

1 0 BL 12-5-2

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat									
Powder Coating									
	Memo	0.00							
	1- touch up corner with alodine only								
	2- Plug holes prior to								
	1ST COAT: <u>11:00</u>								
	START TIME: <u>3200F</u>								
	OVEN TEMPERATURE: <u>320</u>								
	FINISH TIME: <u>11:20</u>								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
170	QC3- Inspect Part Finish	0.00							
170									
QC									
Quality Control	Memo	0.00							

M121134

1X ~~0~~ M/L 12/5/02

1X ~~0~~ M 12/5/02

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* HandFinish Hand Finishing	Assemble as per dwg Memo 1- Install webbing as per dwg 2- Install placard and label as per dwg	0.00 0.00				1x			ES 12/05/04
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		51765104					
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: 6-A Memo w/o 82526	0.00 0.00				1x			ES 12/05/04

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Start Date: 02/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MCS 12/05/04
MCS 12/05/04

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Picklist Print

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Page 1

Work Order ID: 82532

82532

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2957 *D2957* Mounting Plate		Manufactured	No			100	Each	9.0000	4	4			
				<u>Location</u>				<u>Loc Qty</u>					
				WA005				9					
				71221				9		4			
D3915-1 *D3915-1* Rib		Manufactured	No			100	Each	4.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>					
				WA006				4					
				73204				4		2			
D4016-5 *D4016-5* Hinge Half, Light Lid		Manufactured	No			100	Each	9.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>					
				WA005				9					
				66335				3		3			
				74468				6					
D4019-3 *D4019-3* Rib		Manufactured	No			100	Each	5.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>					
				WA006				5		3			
				68605				5					

**

**

**

**

12.04.26

12.04.26

12.04.26

12.04.26

37467

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 82532

82532

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-045

Manufactured No

100

Each

1.0000

1

1

D4035-045

Lid Rib Assembly, Fwd (Light)

**

12.04.26

Location

Loc Qty

Loc Code

WA006

1

68545

1

D4035-047

Manufactured No

100

Each

2.0000

1

1

D4035-047

Lid Rib Assembly, Aft (Light)

**

12.04.26

Location

Loc Qty

Loc Code

WA006

2

71225

2

D4056-1

Manufactured No

100

Each

3.0000

1

1

D4056-1

Label Plate

**

12.04.26

Location

Loc Qty

Loc Code

WA005

3

70338

3

D2728-1

Manufactured No

180

Each

0.0000

1

1

D2728-1

Dart Logo label

**

SP

D4029-041

Manufactured No

180

Each

3.0000

1

1

D4029-041

Webbing (Long Basket)

**

SP 12-05-03

Location

Loc Qty

Loc Code

st503

3

69499

3

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-02-12 3:09:39 PM

Work Order ID: 82532

82532

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 02/04/2012

Required Date: 04/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

180

Each

1,134.000

34

34

MS20600-AD4W3

Cherry Rivets

**

SP

Location

Loc Qty

Loc Code

ST321

1001

111636

36

117601

25

118626

600

120308

340

34x

WA018

133

107939

133

NAS1149DN416J

Purchased

No

180

Each

215.0000

34

34

NAS1149DN416.J

Washer

**

SP 12-05-03

Location

Loc Qty

Loc Code

ST297

215

114348

11

114597

119

13910

85

34x

Kit

D4085-3

14

D4086-220

14

B69500A

SP 12-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

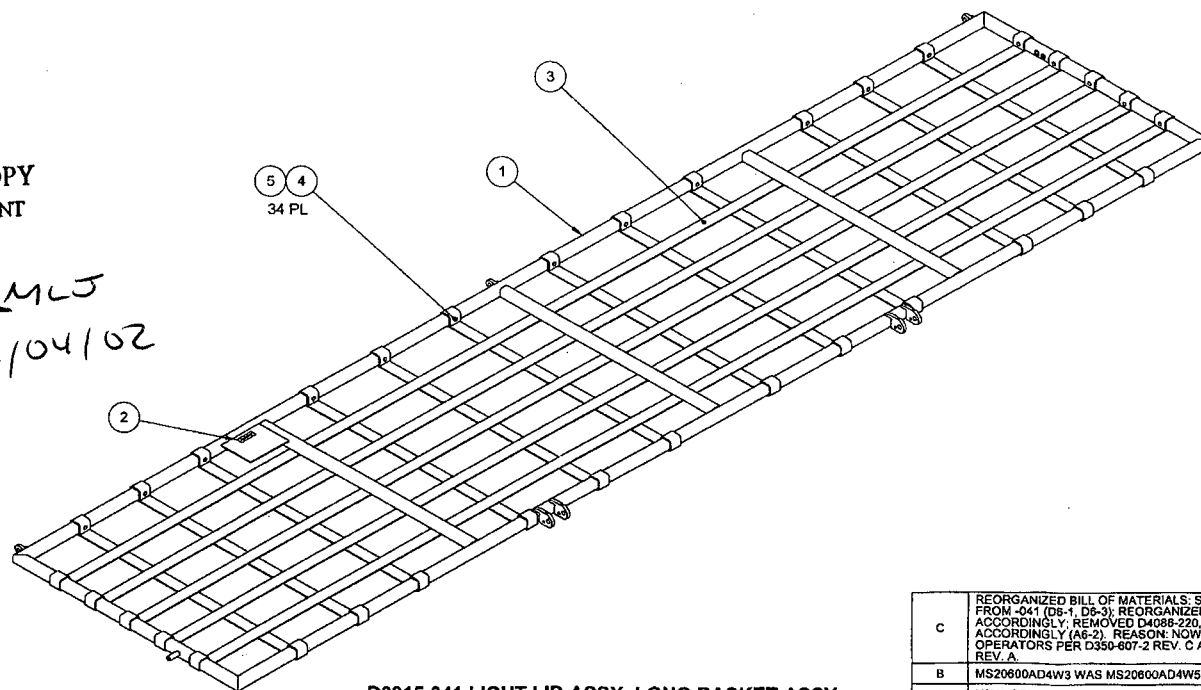
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82532 MJS
12/04/02



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

RELEASED
10.08.05
ECN 10-596

C	REORGANIZED BILL OF MATERIALS; SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4088-220, UPDATED VIEW E ACCORDINGLY (A6-2); REASON: NOW INSTALLED BY OPERATORS PER D330-607-2 REV. C AND D330-607-3 REV. A	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5; BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SA	DRAWING NO.	REV. C
CHECKED	SA	D3915	SHEET 1 OF 4
MFG. APPR.	MP	TITLE	SCALE
APPROVED	MP	LIGHT LID ASSY-LONG BASKET NTS	
DE APPR.	MP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

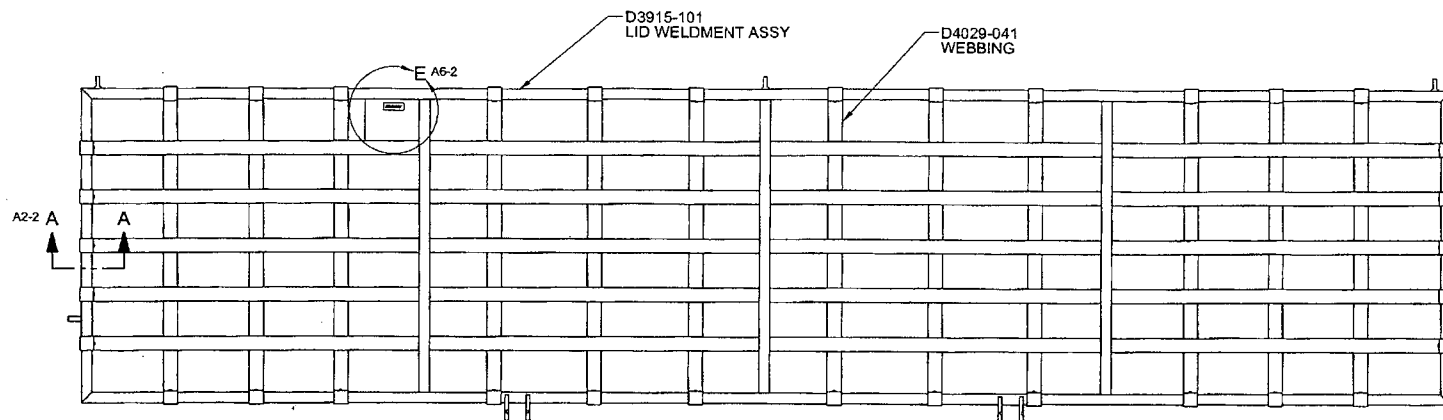
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

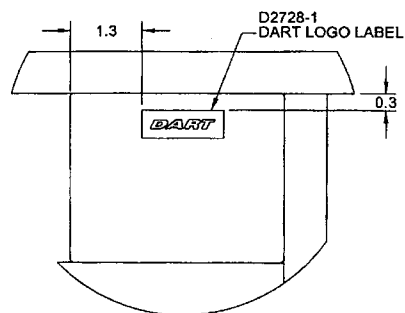
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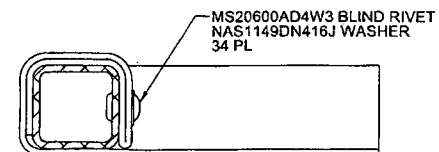
82538



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10-10-12

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SE	DRAWING NO. D3915	REV. C
CHECKED	SE		SHEET 2 OF 4
MFG. APPR.	SE	TITLE	SCALE
APPROVED	SE	LIGHT LID ASSY-LONG BASKET	NTS
DE APPR.	SE	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

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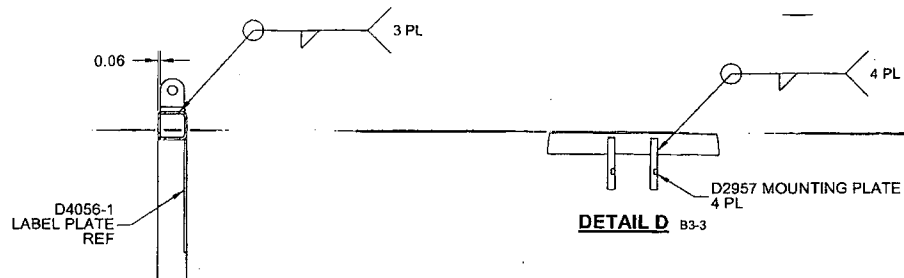
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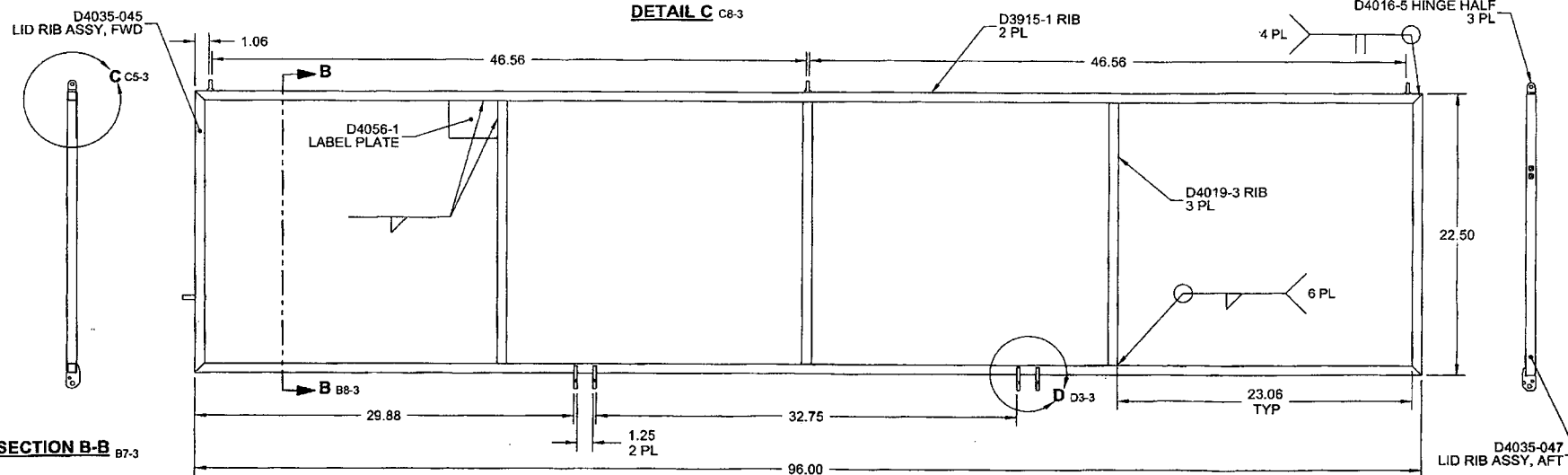
NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



Handwritten: 82532
82532

DETAIL C C8-3



D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D3915	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LIGHT LID ASSY-LONG BASKET	NTS
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

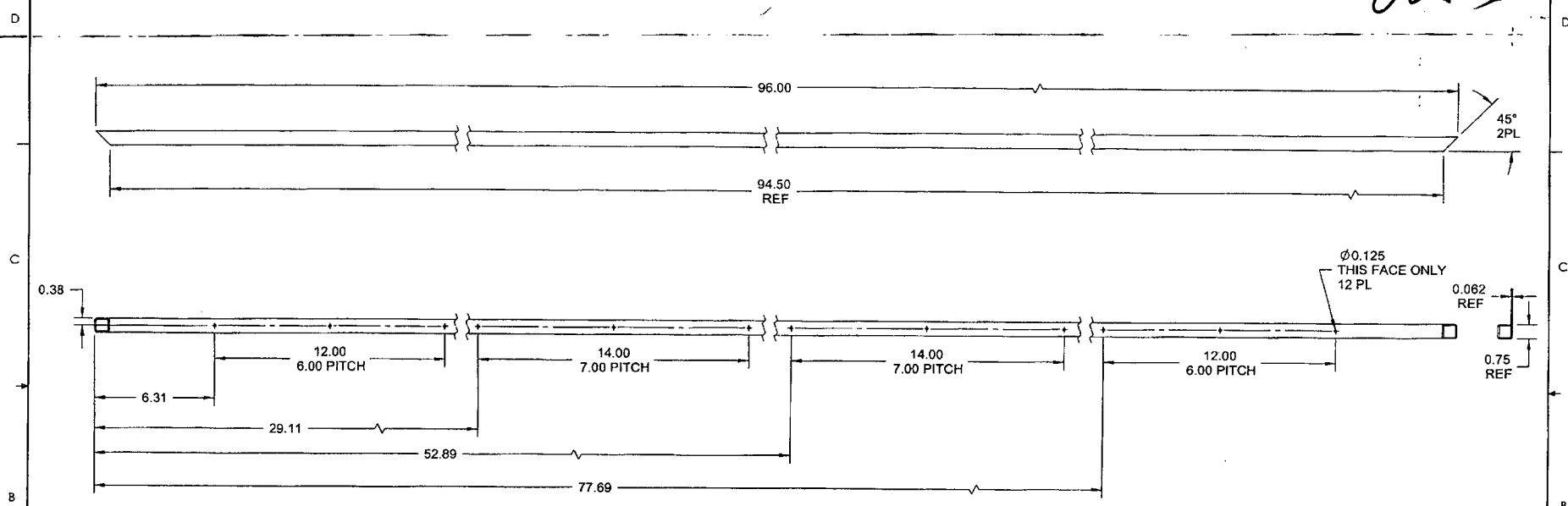
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

02532



D3915-1 RIB

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.49 lbs

RELEASED
10.01.12 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries